

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020176**Date Inspected:** 03-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 9DE / North of Bay 14

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welder is identified as #067656 welding fillet weld (FW) in the 4G position using welding procedure specification (WPS), WPS-B-P-2114-Tc-U4b-FCM-1. The weld is identified as OBE9E-016. ZPMC QC inspectors are identified as, Mr. Li Ping and Certified Welding Inspector (CWI), Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 9BW / North of Bay 17

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #066413 welding FW weld in the 3G position using WPS-B-P-2213-FCM-1. The weld is identified as OBW9G-005. ZPMC QC inspectors are identified as Mr. Li Ping and CWI, Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DW / Bay 14

This Caltrans QA inspector observed Submerged Arc Welding (SAW) in progress. Welder operator is identified as #045270 welding complete joint penetration (CJP) weld in the 1G position using WPS-B-T-2221-B-L2c-S-2. The weld is identified as SEG071*-002. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

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OBG Segment Name: 10AW / Bay 14

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #067329 welding FW weld in the 4G position using WPS-B-P-2114-FCM-1. The weld is identified as SSD11A-PP87-190. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Jie. The welding variables recorded by QC appeared to comply with the WPS

OBG Segment Name: 11CW / Bay 13

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #044801 welding CJP weld in the 2G position using WPS-B-T-2232-TC-U4c-F. The weld is identified as #SSD14A-PP103-257. ZPMC QC inspectors are identified as Mr. Guo Xing Hui and CWI, Mr. Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
